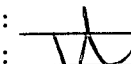
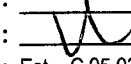


Date: Thursday, 17/08/2006 3:29:15 PM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : FUEL PURGE CANISTER
<b>Job Number</b> : 28225A	
<b>Estimate Number</b> : 10441	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D32621
<b>This Issue</b> : 17/08/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D3262 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 26761A	<b>Material</b> : N/A
<b>Written By</b> : 	<b>Due Date</b> : 10/09/2006
<b>Checked &amp; Approved By</b> : 	<b>Qty:</b> 8 <b>Um:</b> Each
<b>Comment</b> : Est. C 05.03.10 Removed P/O for liquid penetrant inspection K J/JLM	

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6T5000W125

6061-T6 Tube 5.00X.125W



**Comment:** Qty.: 0.9406 f(s)/Unit Total : 7.5247 f(s)  
 Material: 6061-T6 (QQ-A-200/8 or 225/8) 5.00 OD x 0.125" wall  
 (M6061T6T5.000W.125)  
 Identify as D3262-1  
 Batch: M100804

MF. 06-08-28

2.0

BAND SAW

BAND SAW

JAESPA SAW



**Comment:** BAND SAW JAESPA SAW  
 Cut D3262-1 to length as per Dwg D3262  
 Identify as D3262-1

MF. 06-08-28

3.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



**Comment:** SMALL & MEDIUM FAB RESOURCE 1  
 Deburr

MF. 06-08-28

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

MF. 06-08-28

5.0

QC8

SECOND CHECK

**Comment:** SECOND CHECK

MF. 06-08-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/08/31  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 17/08/2006 3:29:15 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER

Job Number: 28225A

Part Number: D32621

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 81*

*PB*

*06/08/30*

*8*

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*8*

*06/08/31*

Job Completion



*C206108130*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

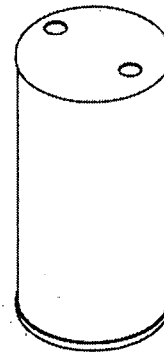
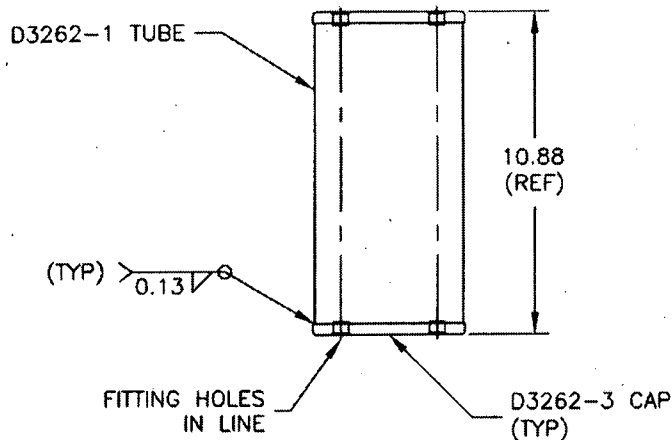
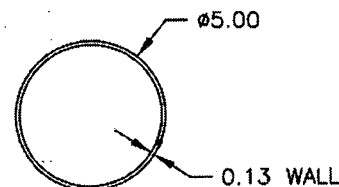
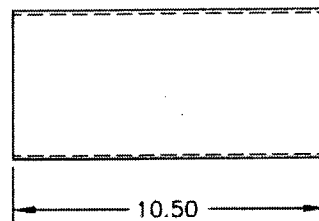
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3262	REV. B SHEET 1 OF 2
DATE 05.02.14		TITLE FUEL PURGE CANISTER	SCALE 1:1
A	04.05.06	NEW ISSUE	
B	05.02.14	ADD PRESSURE TESTING OPTION	

**RELEASED**  
05.02.14**D3262-041 CANISTER ASSEMBLY****REFERENCE ONLY****1 D3262-1 TUBE****D3262-041:**

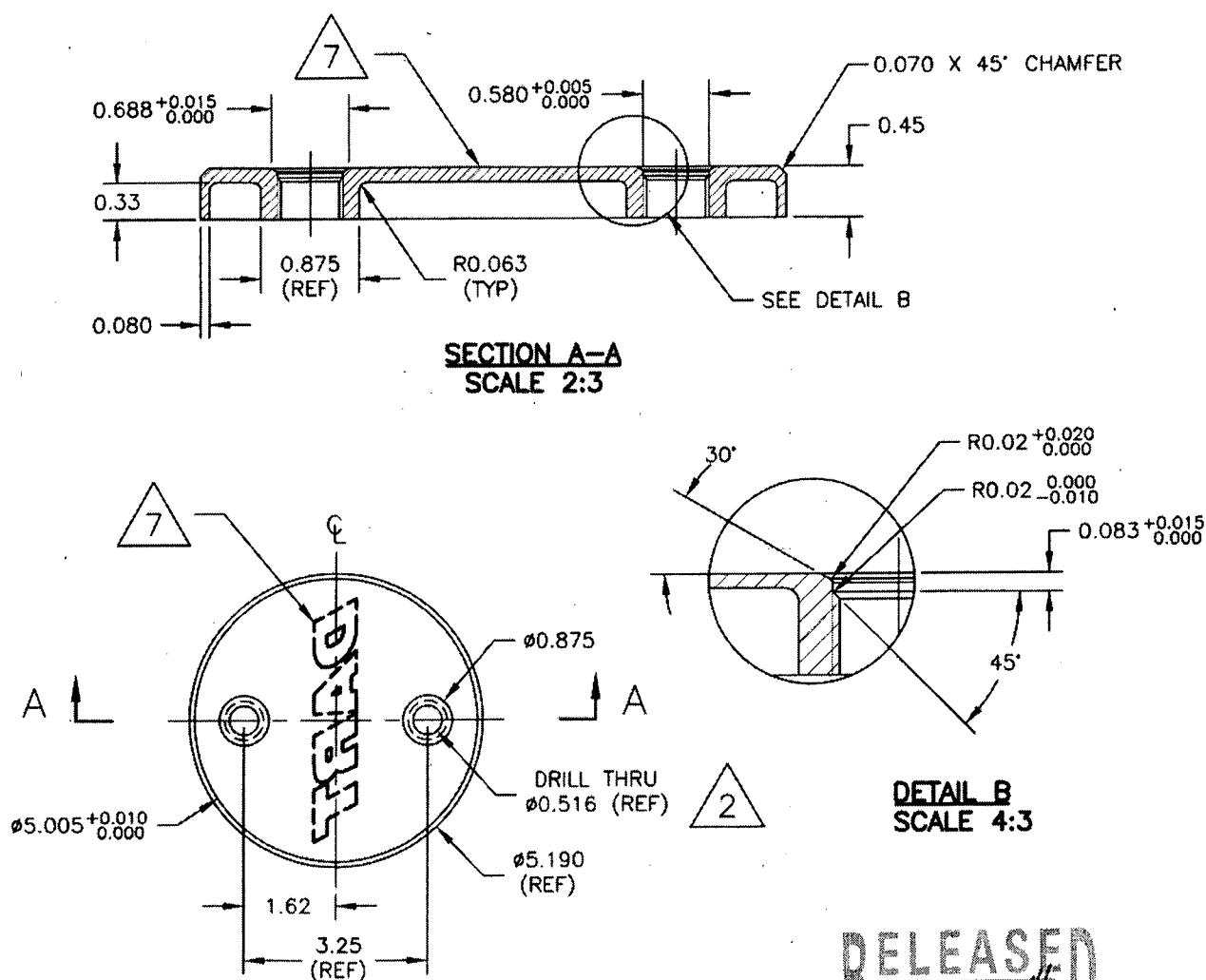
- 1) MATERIAL: 6061-T6 (WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8)  
TUBING 5.00 OD x 0.125 WALL (6061T6T5.000W.125)
- 2) WELD PER QSI 004.
- 3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR PRESSURIZE TO 10 psi  
AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 8) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

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**DART**

DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3262	REV. B SHEET 2 OF 2
DATE 05.02.14		TITLE FUEL PURGE CANISTER	SCALE 1:3



**SECTION A-A**  
**SCALE 2:3**

**DETAIL B**  
**SCALE 4:3**

**D3262-3 CAP**

RELEASED  
05.02.14 [Signature]

**D3262-3**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR  
(REF. DART SPEC. M6061T6B)
- 2) TAP HOLE 9/16-18 UNF-3B PER MIL-S-8879
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH X 0.010 DEEP  
(MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

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